

Date:
User:Tuesday, 10/3/2006 3:48:13 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28865B
Estimate Number : 10395
P.O. Number : N/A
This Issue : 10/3/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : MACHINED PARTS
Previous Run : 28268B
Written By : JA 06 10 03
Checked & Approved By : JA 06 10 03
Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Drawing Name : RING
Part Number : D29685
Drawing Number : D2968
Project Number : N/A
Drawing Revision : B1
Material : N/A
Due Date : 10/30/2006 **Qty:** 30 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M4130NT3000W500 4130 Tube 3"ODx.5"W



Comment: Qty: 0.0218 f(s)/Unit Total: 0.4368 f(s)
 Material: AISI 4130 Ø 3.00 .500" WALL " Bar
 (M4130N-R0.750) Batch: 18948 x5
 Identify AS D2968-1 102020 x18

Qty: 0.0559 f / unit
 Total: 1.117 f

JA 06 10 16

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE
 1-Turn Blank as per Folio FA049 and Dwg D2968
 2-Deburr, no sharp edges

BC 06.10.09

20410 M8

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 06.10.09

20410 M8

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 06/10/09

20410

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST396

PC 06/10/16 (30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.10.09	1	Mat'l quantity change permanent chg	BG			U 06.10.16	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RING

Job Number: 28865B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(38)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/16

Job Completion



u 86-10-16

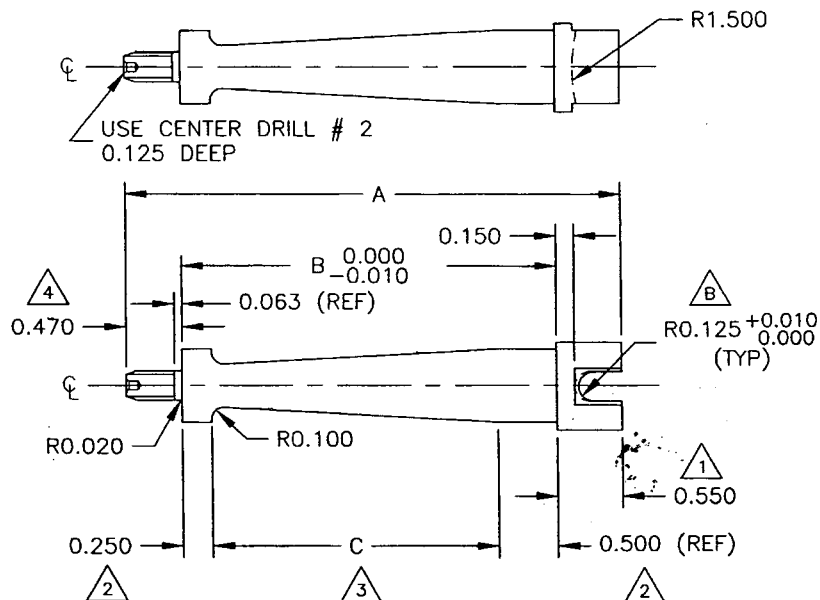
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

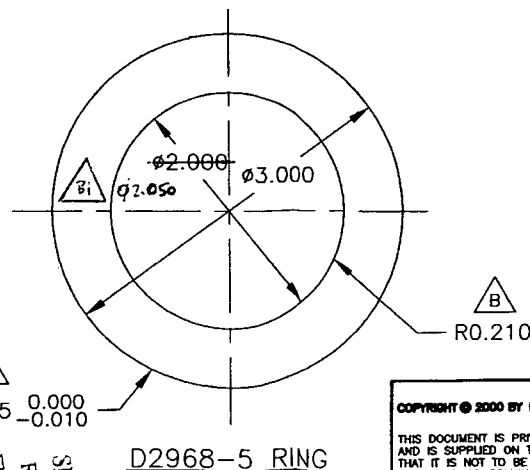
△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED

UNDER REVIEW

USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING

HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART
CHECKED	RF	DART
DATE	00.05.31	TOW RING
DRAWING NO.	D2968	REV. B
TITLE	TOW RING	SHEET 1 OF 1
SCALE		1:1

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